Wednesday, 13/02/2008 1:18:38 PM

Linda Lacelle User:

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number **Estimate Number** : 37401

P.O. Number

: 13169

Written By

Comment

: 13/02/2008

This Issue Prsht Rev.

: NC

Checked & Approved By

First Issue **Previous Run**

: 37306

: //

Type

S.O. No. :

: MACHINED PARTS

08-01-30 new issue DD verifyed by:

Part Number Drawing Number

Drawing Name

: D37301

: ANGLE

: D3730 U/R : N/A

Project Number Drawing Revision

: U/R Material

Due Date : 13/02/2008

Qty:

′10 **Um**:

Each

Additional Product

Job Number:



Seq. #:

1.0

2.0

3.0

5.0

Machine Or Operation:

: Est Rev:A

Description:

D6207

Angle Extrusion 1x1x.125



Comment: Qty.:

0.1749 f(s)/Unit

Total:

1.7493 f(s)

D6207 angle extrusion Batch: 35760

MILLING CONV

CONVENTIONAL MILLING MACHINE

Comment: 1- Mill as per dwg D3730

2-Deburr

QC2

INSPECT PARTS AS THEY COME OFF MACHINI



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8

SECOND CHECK



Comment: SECOND

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Grind radius as per dwg D3730

2- Deburr if necessary



Dart Aerospace Ltd

W/O:		WORK ORDER CHA	ANGES		*****		
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
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		i					
Part No	•	PAR #: Fault Category:	NCR: Yes	No DG	A:	Date:	J
			QA: I	N/C Close	ed:	Date:	
		WORK ORDER NON CONFO	DRAANCE /NO	חו			•

Corrective Action Initial Action Descrip thief Eng Chief Eng		rification Approval	T
		micauon Approval	- Ammental
Office Eng	Date	Section C Chief Eng	Approval QC Inspector
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	ef Eng Chief Eng	Teng Chief Eng Date	TENG Chief Eng Date

NOTE: Date & initial all entries

Date: Wednesday, 13/02/2008 1:18:38 PM User: Linda Lacelle **Process Sheet** Drawing Name: ANGLE Customer: CU-DAR001 Dart Helicopters Services Job Number: 37401 Part Number: D37301 Job Number: Seq. #: Description: **Machine Or Operation:** INSPECT WORK TO CURRENT STEP 6.0 QC5 Comment: INSPECT WORK TO CURRENT STEP PACKAGING RESOURCE #1 PACKAGING 1 7.0 **Comment: PACKAGING RESOURCE #1** Identify and Stock Location: FINAL INSPECTION/W/O RELEASE QC21 8.0 Comment: FINAL INSPECTION/W/O RELEASE mi 2006/3/13 Job Completion OSITIVE RECALL FASED _____ DATE

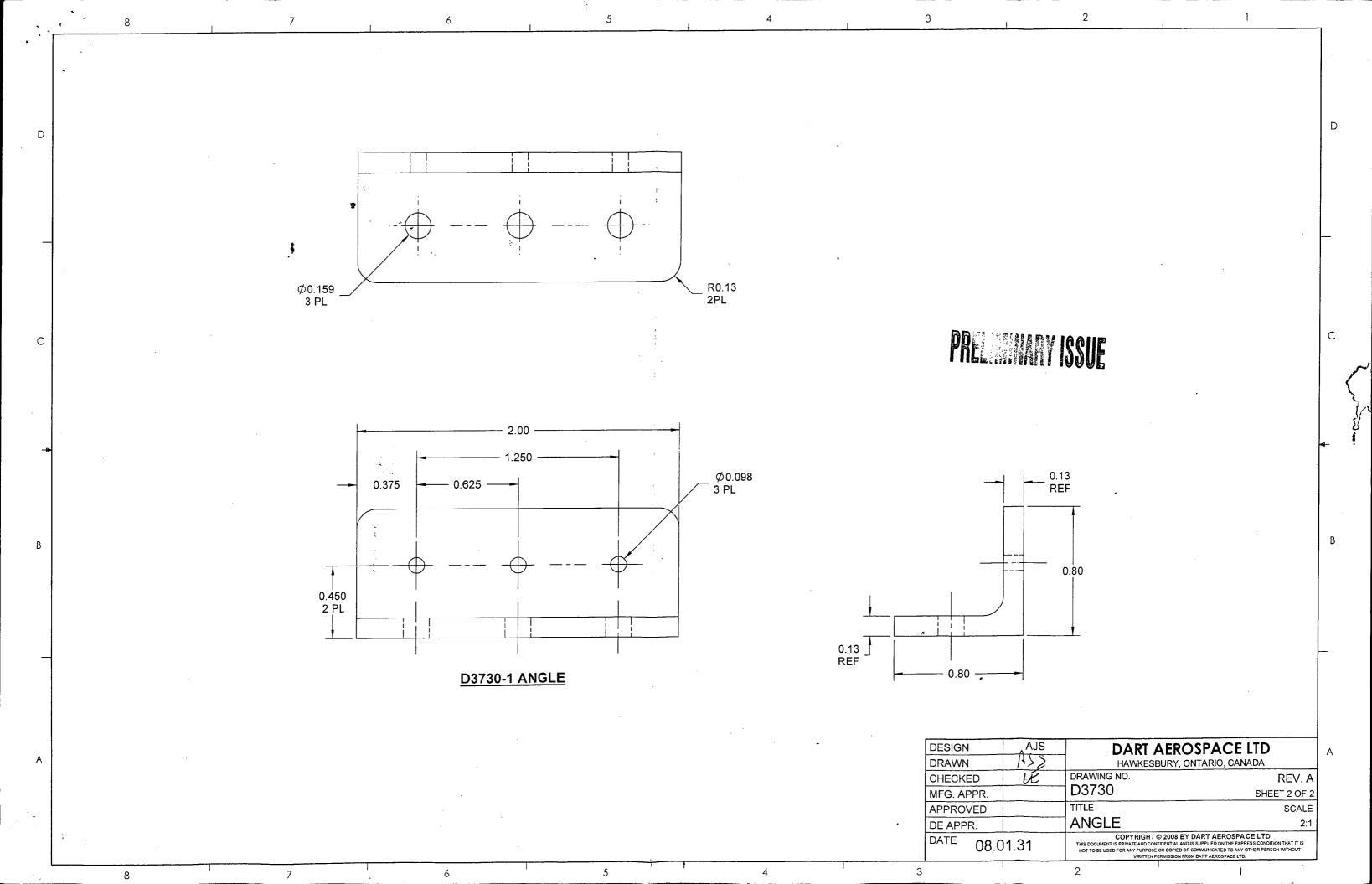
Dart Aerospace Ltd

W/O:			WORK ORDER	CHANGES				
DATE	STEP	PRO	OCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
Part No	:	PAR #:	Fault Category:	NCR: Y	es No DO	QA:	Date: _	
				Q	A: N/C Close	ed:	Date:	
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B			Ammayal	Annewal			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspecto			

NOTE: Date & initial all entries

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Description:					Part Number	er:	
	Rev:			+		Pag	e 1 of 1
Inspection Dwg:							
	FIRST /	ARTICLE IN				<i>₽</i>	
		First Artic	le	Prot	otype	1	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Con	nments
- 2.00	+/- 1030	2,800					
		, 376					
.375	+/-,010	.627					
1625	+/-,010	1.250					
1.250	• •	,450					
	1/010			·			
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Measured by:			<u></u>			Date:	
Date:	8/02/14		1150180			Revised by	Approved
Rev Date	Change					(J/RF	



0 0 D3730-1 ANGLE

PRELIMINARY ISSUE

NOTES:

1) MATERIAL: MAKE FROM D6207 OR D6203 EXTRUSION

2) FINISH: MEMBE CHEMIAL COMMISSION

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: 0.04 lbs

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Α	NEW IS	SUE	AJS	08.01.31					
REV.			DESCRIPTION	BY	DATE				
DESIGN	1	AJS	DART AE	DART AEROSPACE LTD					
DRAWN /		11/5	HAWKESBURY, ONTARIO, CANADA						
CHECKED LE		IR	DRAWING NO.	REV. A					
MFG. APPR.			D3730		SHEET 1 OF 2				
APPROVED			TITLE						
DE APPR.			ANGLE	NTS					
DATE	08.0)1.31	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.						

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